

Date: Monday, 2/13/2006 9:34:13 AM
 User: Linda Lacelle

Process Sheet

(4)

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 25808					
Estimate Number	: 10384					
P.O. Number	: N/A			Part Number	: D3195043	
This Issue	: 2/13/2006 S.O. No. : N/A			Drawing Number	: D3195 REV A	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: A	
Previous Run	: 25201			Material	: N/A	
Written By	: SEE COMMENT BELOW			Due Date	: 2/20/2006	
Checked & Approved By	: SEE ABOVE DATE & USEC			Qty:	20	Um: Each
Comment	: Est Rev:A New Issue 05-11-08 JLM					

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
		
Comment:	Qty.: 03150 f(s)/Unit Total : 6.3000 f(s) Material: 6061-T6/T651 (QQ-A-200/8) or (QQ-A-225/8) or (QQ-A-250/11) (M6061T6B1.250x1.500) Identify for D3195-3 Batch: M 17037/66" M 16954. / 12"	
2.0	BAND SAW	BAND SAW
		
Comment:	BAND SAW Cut blanks: (1.250" x 1.500") x 3.60" long	J.F. 06/02/17 20
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment:	HAAS CNC VERTICAL MACHINING #1	
1-Machine D3195-3 as per Folio FA334 and Dwg D3195 Identify as D3195-3		
2-Deburr		J.F. 06/02/17 20
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/02/17 20
5.0	QC8	SECOND CHECK
		
Comment:	SECOND CHECK	S.N. 06-02-17 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/13/2006 9:34:13 AM
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Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06/02/18 20

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FC 06/02/21

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 06/02/21

9.0 D31957 Pad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3195-7 PAD B25847

SAP 06/02/21

10.0 SMALL FAB 1. SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond D3195-7 into D3195-13as per Dwg D3195

Pick:

Qty Description Batch

A/R Contact Cement M100008

Identify as D3195-043

SAP 06/02/21

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51/37

20/2/21 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

 06-02-27

Job Completion



 06-02-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Bracket	Part Number:	D3195-3
Inspection Dwg: D3195 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>JF</u>	Audited by: <u>SD</u>	Prototype Approval: N/A
Date: <u>06/02/16</u>	Date: <u>06.02.16</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

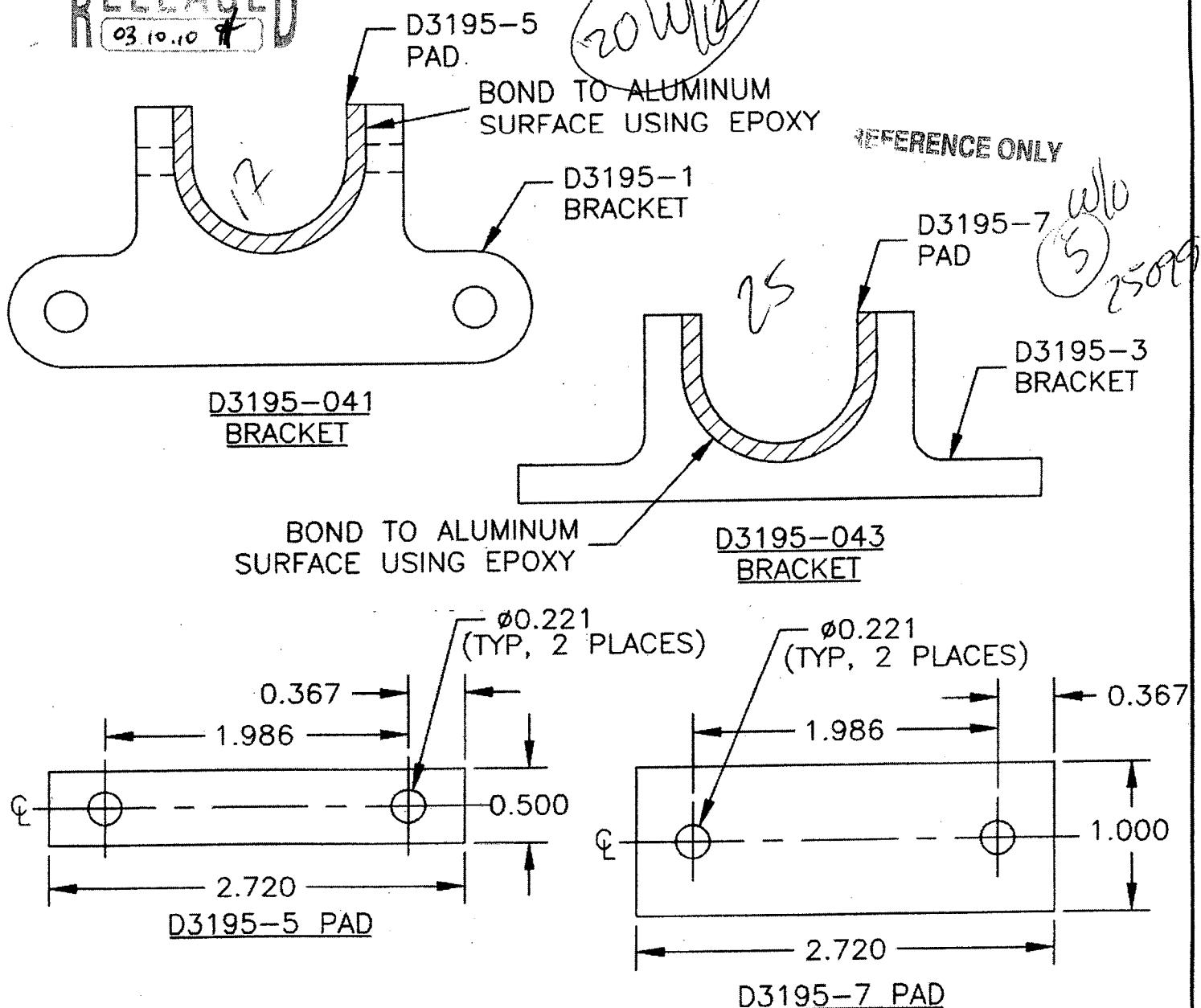
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY IS
OENS

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
DATE	03.06.23			TITLE BRACKET
				SCALE 1:1
A	03.06.23	NEW ISSUE		

RELEASED
03.10.10 #D3195-5 & D3195-7 PAD

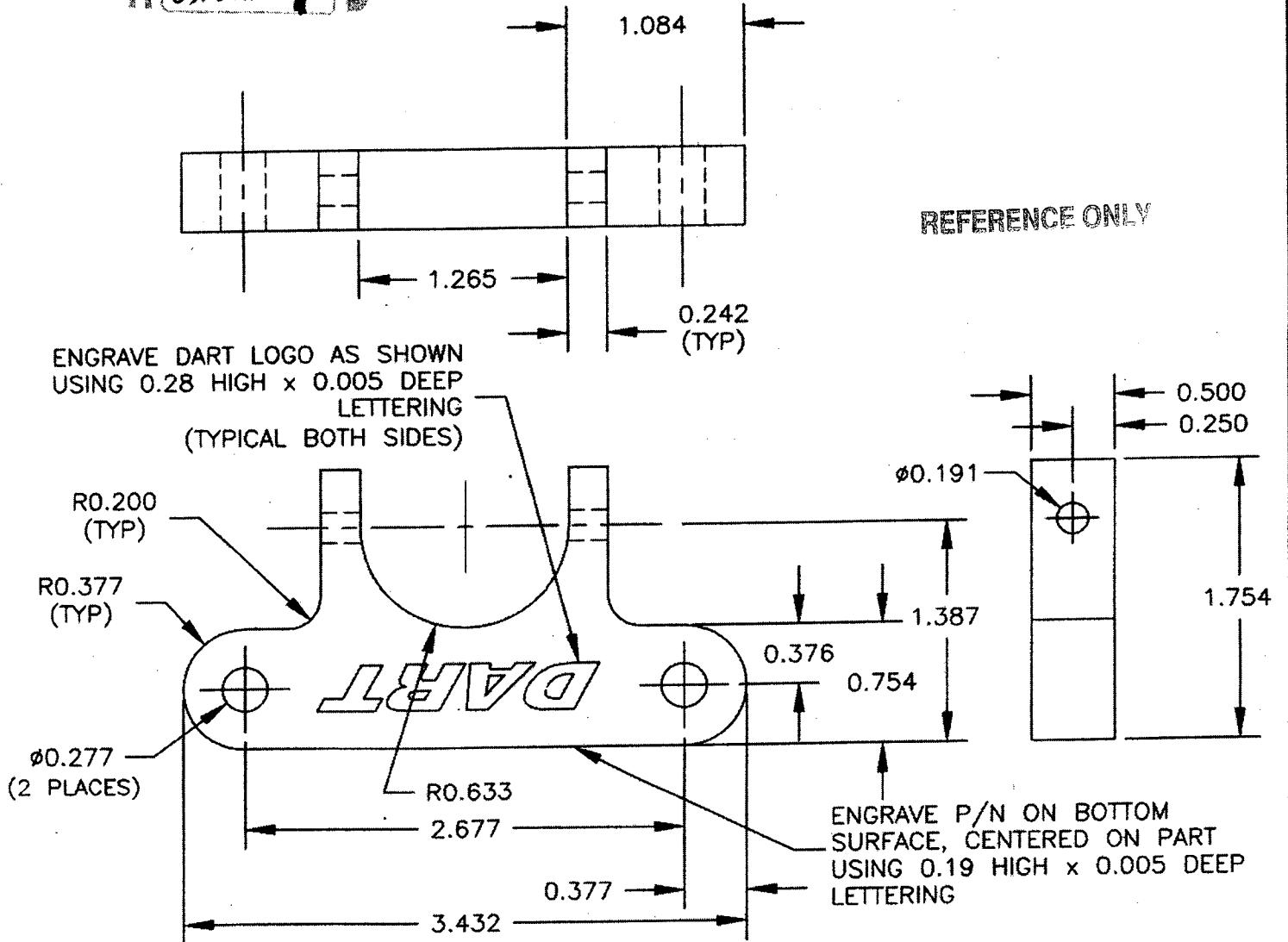
- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
DATE	03.06.23			REV. A SHEET 2 OF 3 SCALE 1:1

RELEASED

03.10.10

**D3195-1 BRACKET**

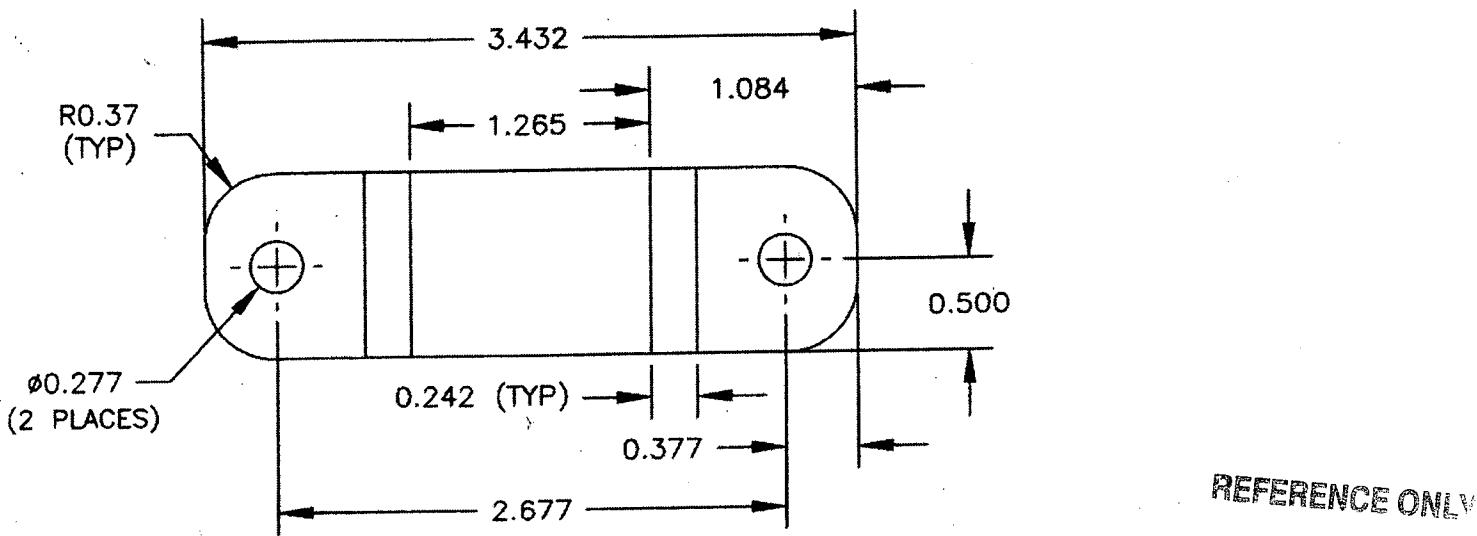
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DART

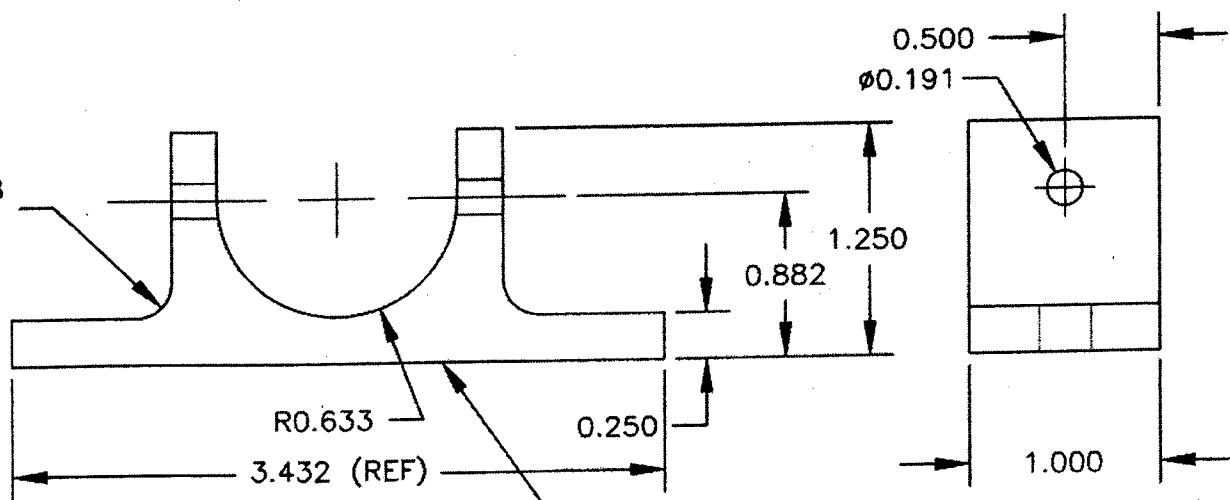
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
		D3195
DATE	TITLE	SCALE
03.06.23	BRACKET	1:1

REV. A

SHEET 3 OF 3



REFERENCE ONLY

**RELEASED**
03.10.10

ENGRAVE P/N ON BOTTOM SURFACE, CENTERED ON PART USING 0.19 HIGH X 0.005 DEEP LETTERING

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

